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02.11.89 Bulletin 89/44(71) Applicant: **DAYTON RELIABLE TOOL & MFG.
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(54) **Air assist means for use in transferring relatively flat objects.**

(57) In a ram press for manufacturing shells for can ends, a relatively flat shell is transferred from a tooling station (72) to a destination (84). The shell is supported at the first station from the upper tooling work surface, from which it is propelled in edgewise fashion into a transfer path (82). The transfer path is at least partially enclosed and extends from an entrance adjacent the first station tooling (72) toward the shell destination (84). An air assist mechanism is provided for acting upon the shell moving into and along the path, and includes an outlet conduit (104) connected to a supply of air under pressure. The conduit includes an open outlet end. A valve (96) controls flow of air along said conduit. The outlet conduit is disposed with its outlet end at one side of the entrance to the transfer path (82), with the end positioned in a direction into the path, whereby air is directed along said path in the direction of movement of the object. The air facilitates movement of the shell along the path.

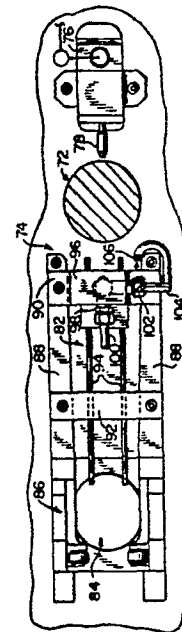


FIG-6

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DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl. 4)
A	GB-A-2 085 783 (THE STOLLE CORP.) * Figure 2; abstract * ---	1-7,9	B 21 D 43/18 B 21 D 51/44
A	US-A-3 387 543 (BECKERS) * Figures 1-3; claims 1-4 * ---	1-3,7-9	
A	US-A-3 185 277 (AGNEW) * Figures 1-10; claim 5 * ---	1,11	
D,A	EP-A-0 149 184 (DAYTON RELIABLE TOOL & MFG. CO.) * Figures 11-16; claims 12-20 * -----	1,10,12 -14	
			TECHNICAL FIELDS SEARCHED (Int. Cl.4)
			B 21 D 43/00 B 21 D 45/00 B 21 D 51/00
The present search report has been drawn up for all claims			
Place of search THE HAGUE		Date of completion of the search 16-08-1989	Examiner SUENDERMANN R.O.
CATEGORY OF CITED DOCUMENTS			
X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document			